

# Work Order ID 67718

Tuesday, March 29, 2011 1:32:29 PM

ASAD



Item ID: D3208-11

Accept



Setup Start



Revision ID:

Item Name: Filler

Stop



Start Date: 3/29/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3208

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3208 11 Dwg Rev: A1 11 Prog Rev: A1 12-  
Deburr if necessary

FB11-3-29

TS

2024. 040

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

FB11-3-29

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sub 03/29

(1)

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

15. BR 11-3-30

140



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

15 of 11 11/3/30

150



Packaging

Identify as per dwg & Stock Location: *700*

0.00

Memo

0.00

Packaging

11/3/30 1528

**Work Order ID 67718**

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Page 3

Item ID: D3208-11

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Revision ID:

Item Name: Filler

Setup Start

Stop

Start Date: 3/29/2011 Start Qty: 10.00

Required Date: 3/30/2011 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/3/31  
ME

11-03-30

# Picklist Print

Tuesday, March 29, 2011 1:32:27 PM

Page 1

Work Order ID: 67718

Parent Item: D3208-11

Parent Item Name: Filler



Start Date: 3/29/2011

Required Date: 3/30/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: A 04.06.09 New issue KJ/RF  
IPP B 08.11.17 Waterjet EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased		No		100	sf	139.0000	0.1646	1.732632	2.5		



2024-T3 .040 sheet



B11-3-29

## Location

## Loc Qty

## Loc Code

MAT022

139

112291

5

112331

64

113162

70

113162

(K)

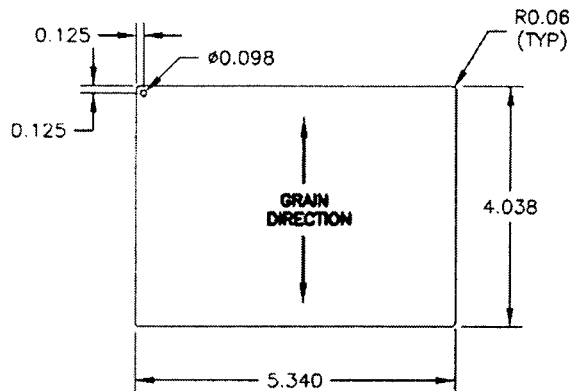




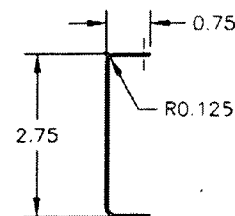
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DATE 04.01.27		TITLE DOUBLER	SCALE 1:3

RELEASED  
24 04 05

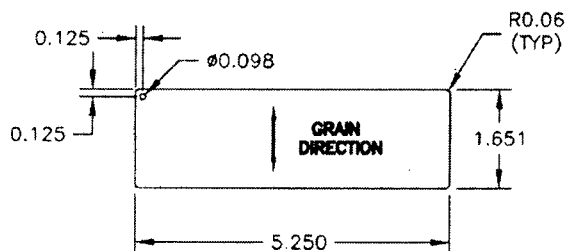
CH 01.27 NEW ISSUE  
[Signature] 04.01.27



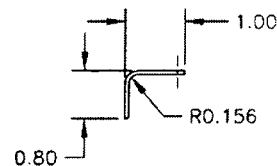
2 D3208-1 DOUBLER  
FLAT PATTERN



D3208-1 DOUBLER  
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE  
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE  
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



W/O 67718

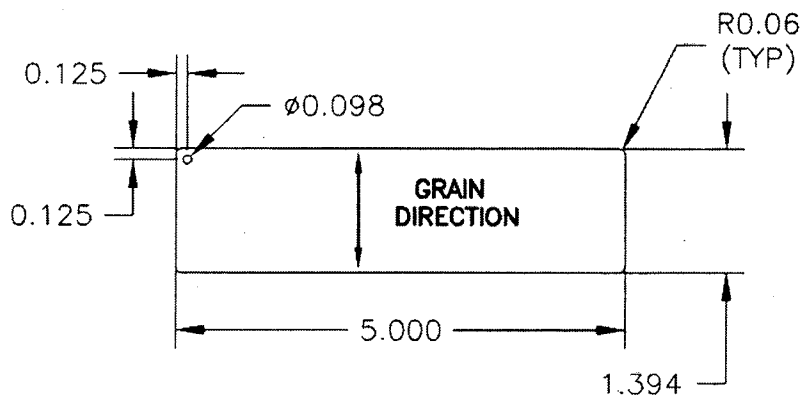
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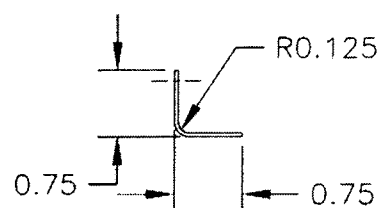


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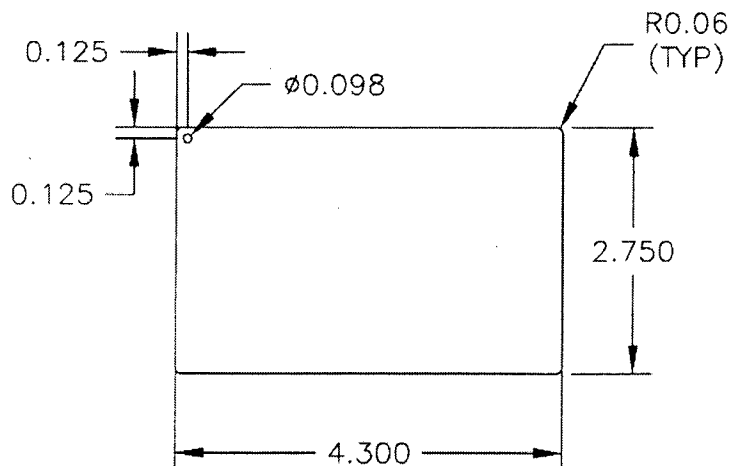
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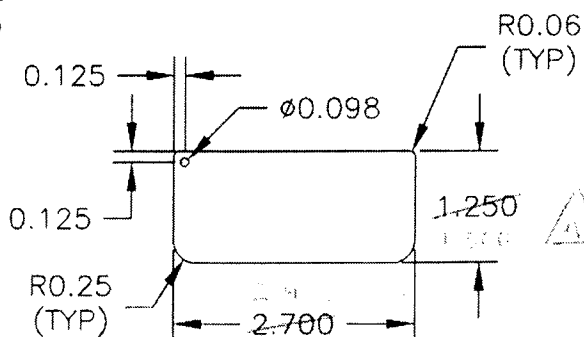
2 D3208-5 MOUNT ANGLE  
FLAT PATTERN



D3208-5 MOUNT ANGLE  
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

CAF718

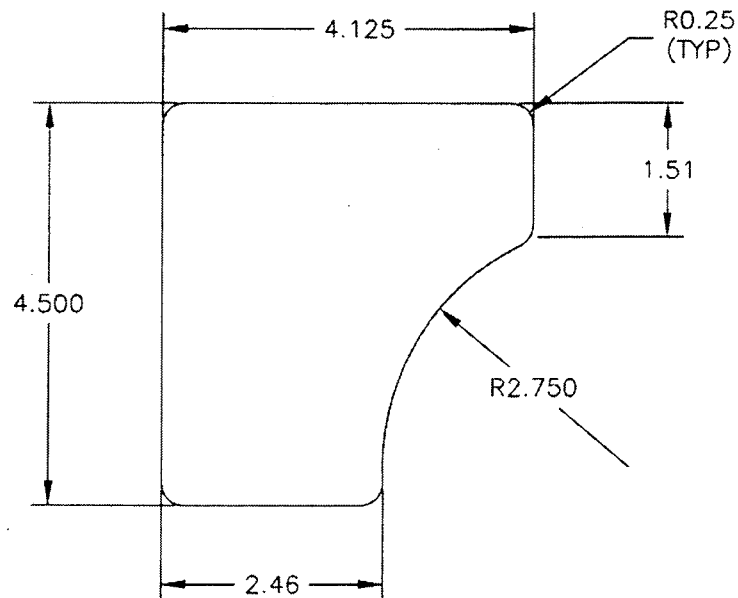
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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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04.05.05



**D3208-9 DOUBLER**

67718

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